

Push Dec 31

Work Order ID 110535

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Item ID: D2332-043 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Lid Prop Assembly 8.00"
Start Date: 12/24/13 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 12/27/13 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2332	Rev C1								

100 0.00
100 Large Fab 2 SMD 13/12/27
Large Fab Memo 0.00
Large Fab Cut to length as per Dwg D2332 (D2332-7) Locking CollarCut to length as per Dwg D2332 (D2332-5) Stop Pin Deburr

110 0.00
110 NC BRAKE 2 SMD 13/12/27
Brake NC Memo 0.00
Brake NC Punch or form to length as per Dwg D2332 (D2332-11) using DT8012(Note: Make (2) D2332-11 Prop Arms per assembly.)
cut at 1.063

120 0.00
120 Small Fab 2 SMD 13/12/27
Small Fab Memo 0.00
Small Fab 1-Drill hole in D2332-1 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly)2-ensure no foreign objects inside fo tube and deburr

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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									
140		0.00							
140	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Weld D2332-1 and D2332-5 as per Dwg D2332 & QSI 004 using Welding Jig DT8298. (Weld 1 per assembly) Identify as D2332-3 ***** insure nothing is inside of tube before welding*****A/R SS Rod Batch: <u>M125054</u> *****brush								
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
150									
QC	Memo	0.00							
Quality Control									

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
160									DAS
QC	Memo	0.00							9
Quality Control									9-89
170		0.00							
170	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Tumble and Deburr								
180		0.00							
180	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Tumble2-Assemble as per Dwg D2332								

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 Revision ID: Stop ***NS2***
 Item Name: Lid Prop Assembly 8.00"
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 Required Date: 12/27/13 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

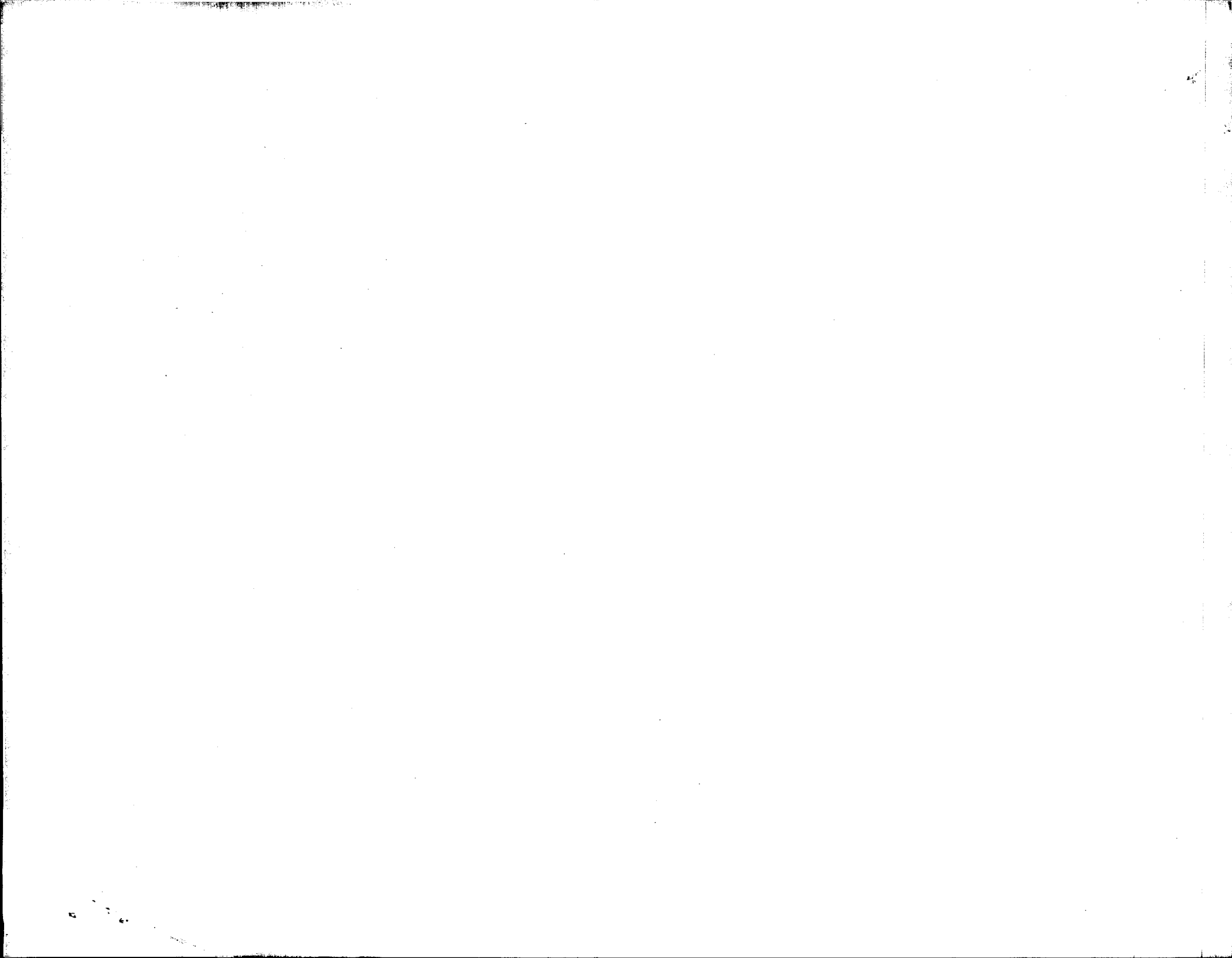
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190	QC5- Inspect part completeness to step on W/O	0.00							
190		0.00							
QC	Memo								
Quality Control									

200	Identify as per dwg & Stock Location: <u>ST255 (1000)</u>								
200	(1x) ship.	0.00							
Packaging	Memo								
Packaging									

210	QC21- Final Inspection - Work Order Release	0.00							
210		0.00							
QC	Memo								
Quality Control									

Handwritten notes:
 2x DAS 28 9-89 13-12-30
 MF 13-12-30
 B-12-30



Picklist Print

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Work Order ID: 110535
Parent Item: D2332-043
Parent Item Name: Lid Prop Assembly 8.00"

Start Date: 12/24/13 Required Date: 12/27/13
Start Qty: 2.00 Required Qty: 2.00

Comments: IPP: B03.07.08Re-issue 8.00"" longKJ/RF
IPP Rev:C 08-06-02 add comment DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-4A BOLT		Purchased	No			180	Each	122.0000	1	2		13/12/30	DAS 36 9-85
<u>Location</u>						<u>Loc Qty</u>	<u>Loc Code</u>						
ST355						122							
m120187						6							
m125709						116							
AN960JD416L Washer	NAS1149D0416J	Purchased	No			180	Each	0.0000	3	6		13/12/30	DAS 36 9-89
M304R.250 304 SS Round bar .250		Purchased	No			110	f	21.0000	-0.1083	0.20	1	13/12/27	
<u>Location</u>						<u>Loc Qty</u>	<u>Loc Code</u>						
MAT028						21							
122682						21							
M304TR0.500W.035 304 RD Tube .500 x .035W		Purchased	No			180	f	41.0000	-1.6666	3.2	4	13/12/27	
<u>Location</u>						<u>Loc Qty</u>	<u>Loc Code</u>						
MAT017						41							
125513						38							
m126922						3							
M304TR1.000W.049 304 RD Tube 1.00 x .049W		Purchased	No			100	f	20.1600	-0.4219	0.83	1	13/12/27	
<u>Location</u>						<u>Loc Qty</u>	<u>Loc Code</u>						
MAT018						20.16							
125250						20.16							

Picklist Print

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Work Order ID: 110535

Parent Item: D2332-043

Parent Item Name: Lid Prop Assembly 8.00"

Start Date: 12/24/13

Required Date: 12/27/13

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

100

Each

3,700.0000

1

2

3/12/30

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Locknut

Location

Loc Qty

Loc Code

GA

82

m126333

82

2

ST509

2000

m127255

2000

ST518

1618

m127376

1618

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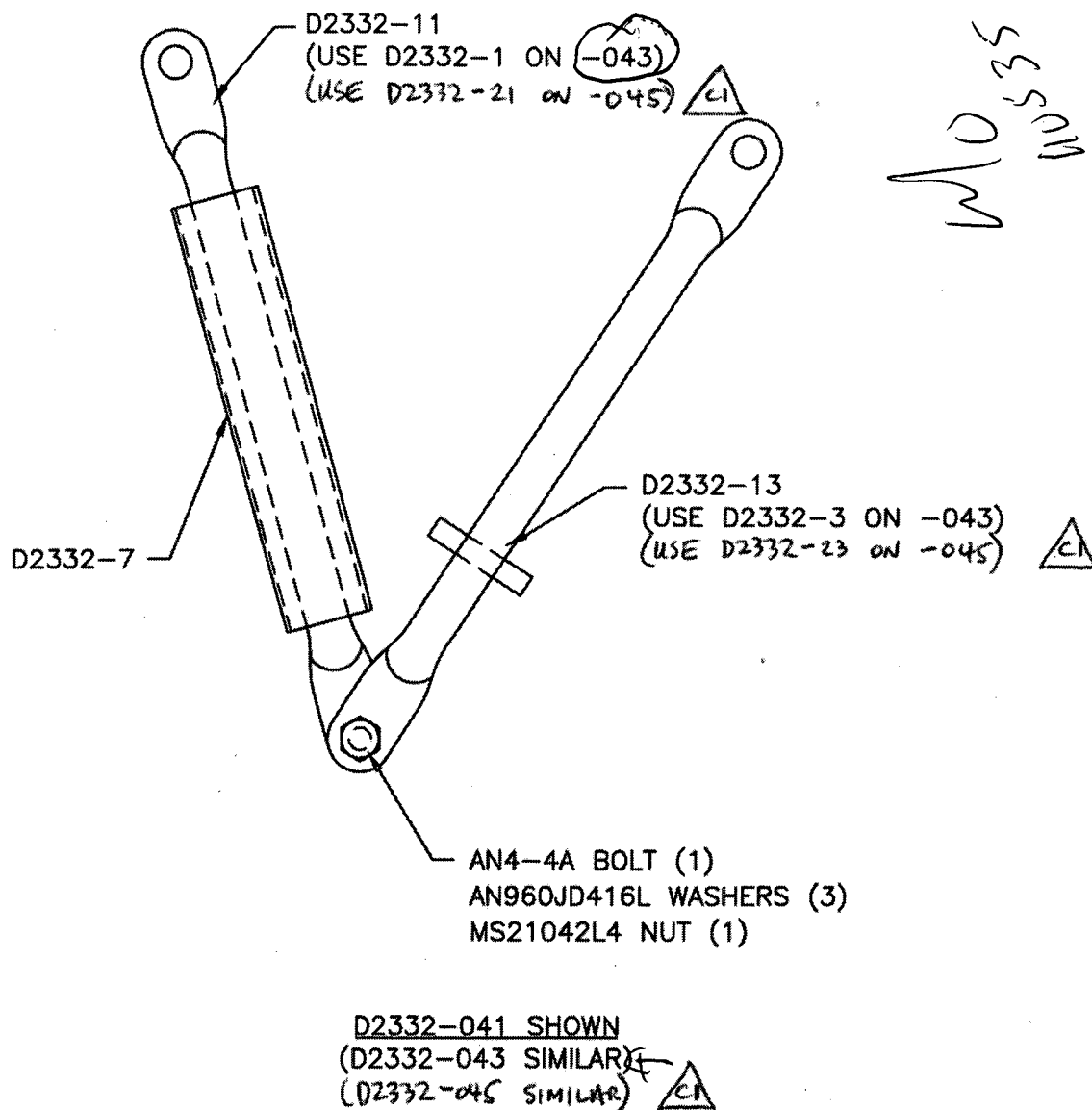
Shop Packet Print

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
CI	03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04

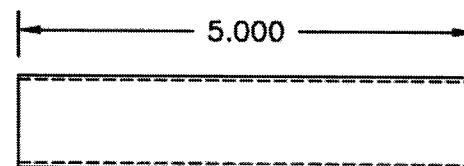


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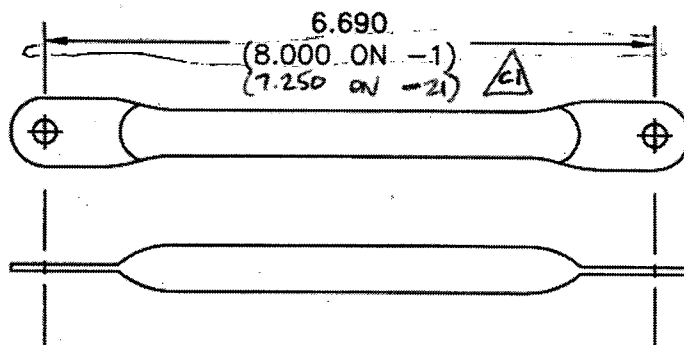
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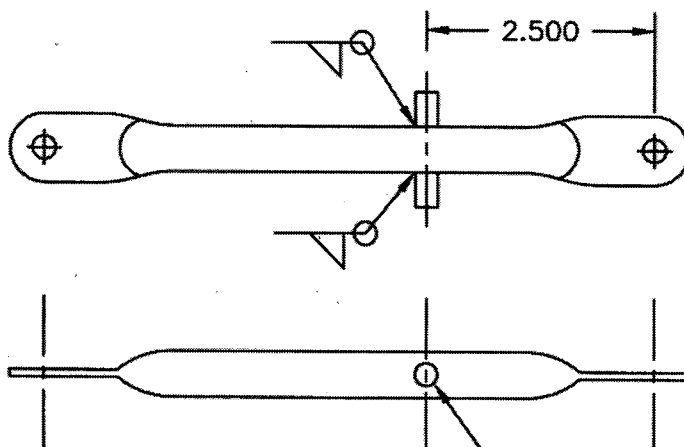
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03.07.03	03.07.03	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
03.07.03	03.08.06	D2332
DATE	TITLE	REV. C
03.07.03	LID PROP ASSEMBLY	SHEET 2 OF 2
		SCALE
		1:2



D2332-7 LOCKING COLLAR



D2332-11 PROP
(D2332-1 SIMILAR)



DRILL 1/4 HOLE FOR D2332-5

D2332-13
M/F D2332-11 & D2332-5

(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)



NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED
03.07.04

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